Rush

Work Order ID 105515 *105515*

August-08-13 8:28:57 AM D2700

Item ID: D2700 B105515 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Upper Arm Clevis **Stop** *NS2*

Start Date: 8/08/13 **Start Qty:** 6.00 8 *6*

Required Date: 8/09/13 **Req'd Qty:** 6.00 *6*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ✓ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2700	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Waterjet FLOW CNC Waterjet 6061 0.250" x 1.25"	**Memo** CUT AS PER FILE PROG REV: B DWG REV: B DEBURR	0.00 / 0.00				17	0		Ae 13.08.10
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 / 0.00				17	0		Ae 13.08.10

PTO →

Work Order ID 105515 *105515*

August-08-13 8:28:57 AM

Item ID: D2700 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Upper Arm Clevis

Start Date: 8/08/13 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 8/09/13 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	DAS 27 13.8.13			17			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				17			DAS 05 13.08.14
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 9:30 ______ OVEN TEMPERATURE: ______ FINISH TIME: 10:00 320°F	0.00 0.00				17X			13/08/15

M12612S

Work Order ID 105515

August-08-13 8:28:57 AM

105515

Item ID: D2700

Revision ID:

Item Name: Upper Arm Clevis

Accept *N900040100*

Setup **Start** *NS1* **Stop** *NS2*

Start Date: 8/08/13 **Start Qty:** 6.00 *6*

Required Date: 8/09/13 **Req'd Qty:** 6.00 *6*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ____________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				17x	d	M	13/08/15
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: STO16 Memo	0.00 0.00				17x			M.Al 13-08-15
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					13/8/20[illegible]		

JMC 13-8-16

Picklist Print

August-08-13 8:28:56 AM

Work Order ID: 105515

Parent Item: D2700

Parent Item Name: Upper Arm Clevis

Start Date: 8/08/13 **Required Date:** 8/09/13

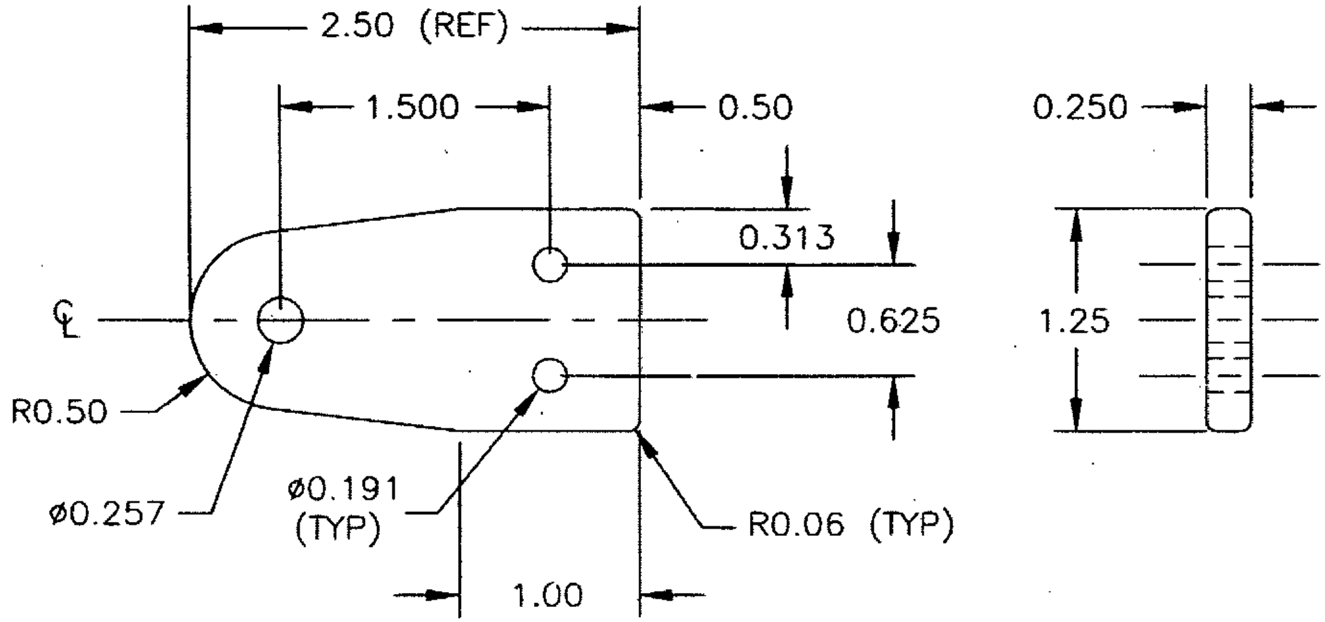
Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X01.250 6061-T6 Bar .250 X 1.25		Purchased	No			100	f	66.8000	0.2292	**1.4475789** MJ25024 →	4.25	13.08.11	

Location		Loc Qty	Loc Code
MAT049		66.8	
	109058	20	
	109140	30.3	
	10956	16.5	

M6061T6
.250 Sheet



W/O 105515

NOTE: DEBURR ALL EDGES R0.030–R0.060
PART IS SYMMETRIC ABOUT CENTERLINE
MATERIAL: 6061–T6 OR 6061–T651 (QQ–A–225/8
OR QQ–A–200/8 OR QQ–A–250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED 99.11.02 KE

DART

QA COPY ISSUED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
KE	KE	D2700	B
CHECKED	APPROVED	SHEET 1 OF 1	
DATE 99.10.20		TITLE: ARM UPPER CLEVIS	SCALE 1:1

REV	DATE	DESCRIPTION
A	97.09.10	NEW ISSUE
B	99.10.20	UPDATE TOLERANCE AND FINISH

DART AEROSPACE LTD	Work Order:	105515
Description: Upper Arm CLEVIS	Part Number:	D2700
Inspection Dwg: 2700 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
ø .257	+.005 -.001	.260	–		V	JKM-01
ø .191	+.005 -.001	.196	–		V	
2.50	+/- .030	2.50	–		V	
1.500	+/- .010	1.500	–		V	
.50	+/- .030	.50	–		V	
.313	+/- .010	.313	–		V	
.625	+/- .010	.625	–		V	
1.00	+/- .030	1.00	–		V	
.250	+/- .010	.257	–		V	

Measured by:	[signature]	Audited by:	04 27 [signature]	Preliminary Approval:	
Date:	13.08.10	Date:	13-8-15	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[signature] 10.04.15

NCR: Yes / No

DQA: [signature] Date: 13/08/22

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: [signature] Date: 13/08/21

Work Order: 105515	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Part No. D2700	Rework [ ]	Skid-tube [ ] Crosstube [ ] Water Jet [✓] Engineering [ ]
NCR No. 13-2966	Scrap [ ]	Machining [ ] Small Fab [ ] Prod. Eng. Coor. [ ] Quality [ ]
	Use-as-is [X]	Thermoforming [ ] Finishing [ ] Rec/Store/Packaging [ ] Other [ ]
	Work Order Update [ ]	Large Fab [ ] Composite [ ] Supplier [ ] [ ]

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data [ ] Equip/Tooling [X] Operator [ ] Material [ ] Setup [ ] Other [ ] Process [ ] Supplier [ ] Training [ ] Unapproved [ ]	13/8/13	160		Ø0.191 holes are oversized from waterjet up to Ø0.205", tapered	[initials] 13/8/13	Acceptable. ~~Ensure [illegible]~~ Ensure there are no ridges from waterjet, Remove if necessary	[initials] 13.08.21	DAS 27 9-89 13.8.20	DAS 16 9-89 13/08/20

FAULT CATEGORY

Landing Gear	General			
[ ] Bending	[ ] Bend	[ ] Grain	[ ] Ovalized	[ ] Pressure/Forced
[ ] Centre Not Concentric to O/S	[ ] BOM/Route	[ ] Hardware	[ ] Over/Under tolerance	[ ] Temperature/Cure
[ ] Cracks	[ ] Broken/Damaged	[ ] Inspection Incomplete	[ ] Part Incorrect	[ ] Weld
[ ] Crushed/Crimped.	[ ] Burrs	[X] Instructions Incomplete/Unclear	[ ] Part Lost/Missing	[ ] Wrong Stock Pulled
[ ] Cuffs	[ ] Contamination	[ ] Maintenance	[ ] Part Moved	
[ ] Heat Treat	[ ] Countersink	[ ] Mislabeled	[ ] Positioned Wrong	
[ ] Inspection Strip in Tube	[ ] Cut Too Short	[ ] Misread	[ ] Power Loss/Surge	[ ] Other
[ ] Ripples in Bend	[ ] Drill Holes	[ ] Offset		
[ ] Torque Waves in Extrusion	[ ] Drawing	[ ] Out of Calibration		
[ ] Turning Sequence	[ ] Finish	[ ] Out of Sequence		
[ ] Wave/Twist in Tube	[ ] Folio	[ ] Outside Dimensions		